

Work Order ID 139237

November 17, 2015 3:29:53 PM

139237

Page 1

Item ID: D3780-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Armrest Assembly

Start Date: 11/17/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/15/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Need By

Approvals:

Process Plan:

SH

Date: 12/15/2015

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3780

Rev D

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- assemble as per dwg D3780
****torque screws 25ft lbs****

Pick kit

DAS
6
9-89

JAN 29 2016

DAS
36
9-89

110

0.00

110

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

JAN 29 2016

DAS
38
9-89

APR 22 2016

DAS
6
9-89

APR 22 2016

120

0.00

120

Identify as per dwg & Stock Location

Packaging

Memo

0.00

Packaging

JAN 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 139237

November 17, 2015 3:29:53 PM

139237

Page 2

Item ID: D3780-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Armrest Assembly
Start Date: 11/17/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 12/15/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MCS APR 22 2016

MCS APR 22 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Picklist Print

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Page 1

Work Order ID: 139237

139237

Parent Item: D3780-041

D3780-041

Parent Item Name: Armrest Assembly

Start Date: 11/17/2015

Required Date: 12/15/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
IPP Rev:B 08-07-22 revB as per dwg verified by:EC
IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3696-041		Manufactured	No			100	Each	4.0000	1	6			DAS 6 9-89
D3696-041													
Arm Assembly													

Location

Loc Qty

Loc Code

ST457

4

B143631x2

103567

1

112427

3

D3781-041

Manufactured No

100

Each

0.0000

1

6

DAS
6
9-89

D3781-041

Lateral Cushion Assembly

D3781-043

Manufactured No

100

Each

1.0000

1

6

DAS
6
9-89

D3781-043

Armrest Cushion Assembly

Location

Loc Qty

Loc Code

ST458

1

87482

1

D3785-3

Manufactured No

100

Each

10.0000

1

6

DAS
6
9-89

D3785-3

Bracket

Location

Loc Qty

Loc Code

ST514

10

56903

7

60559

3

3
3

JAN 29 2016

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Page 2

Work Order ID: 139237

Parent Item: D3780-041

Parent Item Name: Armrest Assembly

139237

D3780-041

Start Date: 11/17/2015

Required Date: 12/15/2015

Start Qty: 6.00

Required Qty: 6.00

D3977-1 Manufactured No

100 Each

5.0000

1

6

D3977-1

Bolt

**

B139539

DAS

6

9-89

Location

Loc Qty

Loc Code

ST067

5

55180

5

5

D3978-1 Manufactured No

100 Each

5.0000

1

6

D3978-1

Nut

**

B139521

DAS

6

9-89

Location

Loc Qty

Loc Code

ST067

5

55182

5

5

D3979-1 Manufactured No

100 Each

26.0000

1

6

D3979-1

Washer

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST067

26

55183

26

6

NAS1149D0332J Purchased No

100 Each

2,019.000

2

12

NAS1149D0332.J

Washer

**

DAS

6

9-89

Location

Loc Qty

Loc Code

CA

14

m129682

14

FP001

76

m129682

76

GA

369

m132677

369

ST264

1560

m133498

1560

12

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Shop Packet Print

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Picklist Print

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Page 3

Work Order ID: 139237

Parent Item: D3780-041

Parent Item Name: Armrest Assembly

139237

D3780-041

Start Date: 11/17/2015

Required Date: 12/15/2015

Start Qty: 6.00

Required Qty: 6.00

AN970-6	Purchased	No	100	Each	33.0000	2	12	
AN970-6								
WASHER								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST329	33	
-------	----	--

M127532	33	
---------	----	--

MS21042L3	Purchased	No	100	Each	517.0000	2	12	
MS21042L3								
Nut								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001	300	
-------	-----	--

M130922	300	
---------	-----	--

GA	90	
----	----	--

M131317	90	
---------	----	--

ST304	127	
-------	-----	--

M133498	127	
---------	-----	--

MS24665-302	Purchased	No	100	Each	51.0000	1	6	
MS24665-302								
Cotter Pin								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

GA	17	
----	----	--

120521	17	
--------	----	--

ST293	34	
-------	----	--

m127305	34	
---------	----	--

JAN 29 2016

Picklist Print

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Page 4

Work Order ID: 139237

139237

Parent Item: D3780-041

D3780-041

Parent Item Name: Armrest Assembly

Start Date: 11/17/2015

Required Date: 12/15/2015

Start Qty: 6.00

Required Qty: 6.00

MS24693-C272

Purchased

No

100

Each

1,088.000

2

12

MS24693-C272

Screw

Location

Loc Qty

Loc Code

cck007a

986

17137

467

17831

519

ST291

102

9370

102

MS24693-C277

Purchased

No

100

Each

92.0000

2

12

MS24693-C277

Screw

Location

Loc Qty

Loc Code

ST291

92

m128060

92

NAS1149D0663J

Purchased

No

100

Each

860.0000

1

NAS1149D0663.J

Washer

Location

Loc Qty

Loc Code

ST260

227

M131618

227

ST260a

566

M132256

266

M133134

300

ST269

67

M126334

67

DAS
6
9-89

DAS
6
9-89

DAS
6
9-89

JAN 29 2016

8

7

6

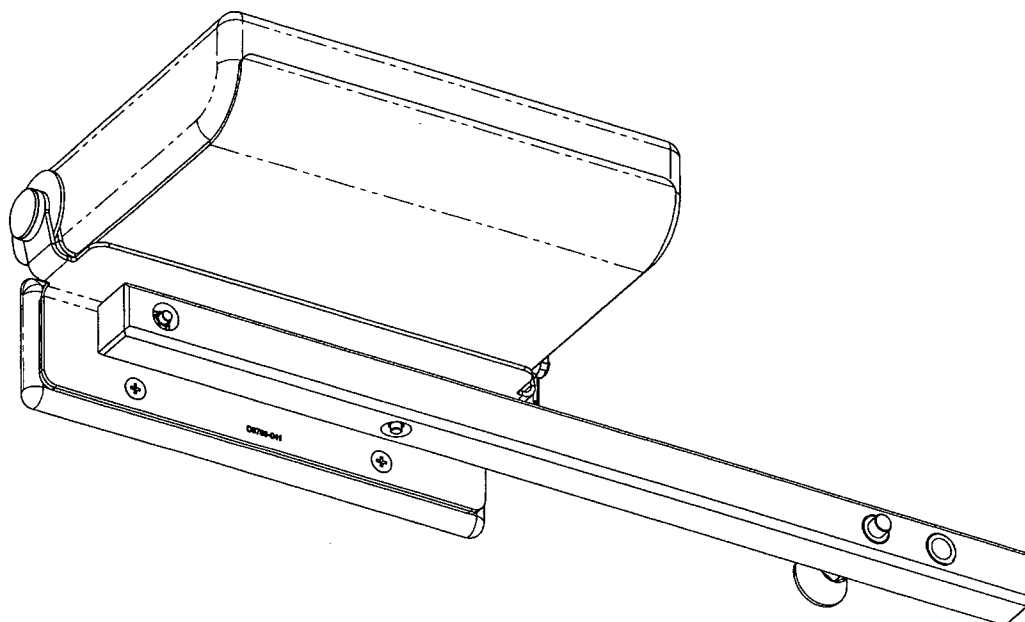
5

4

3

2

1



D3780-041 ARMREST ASSEMBLY

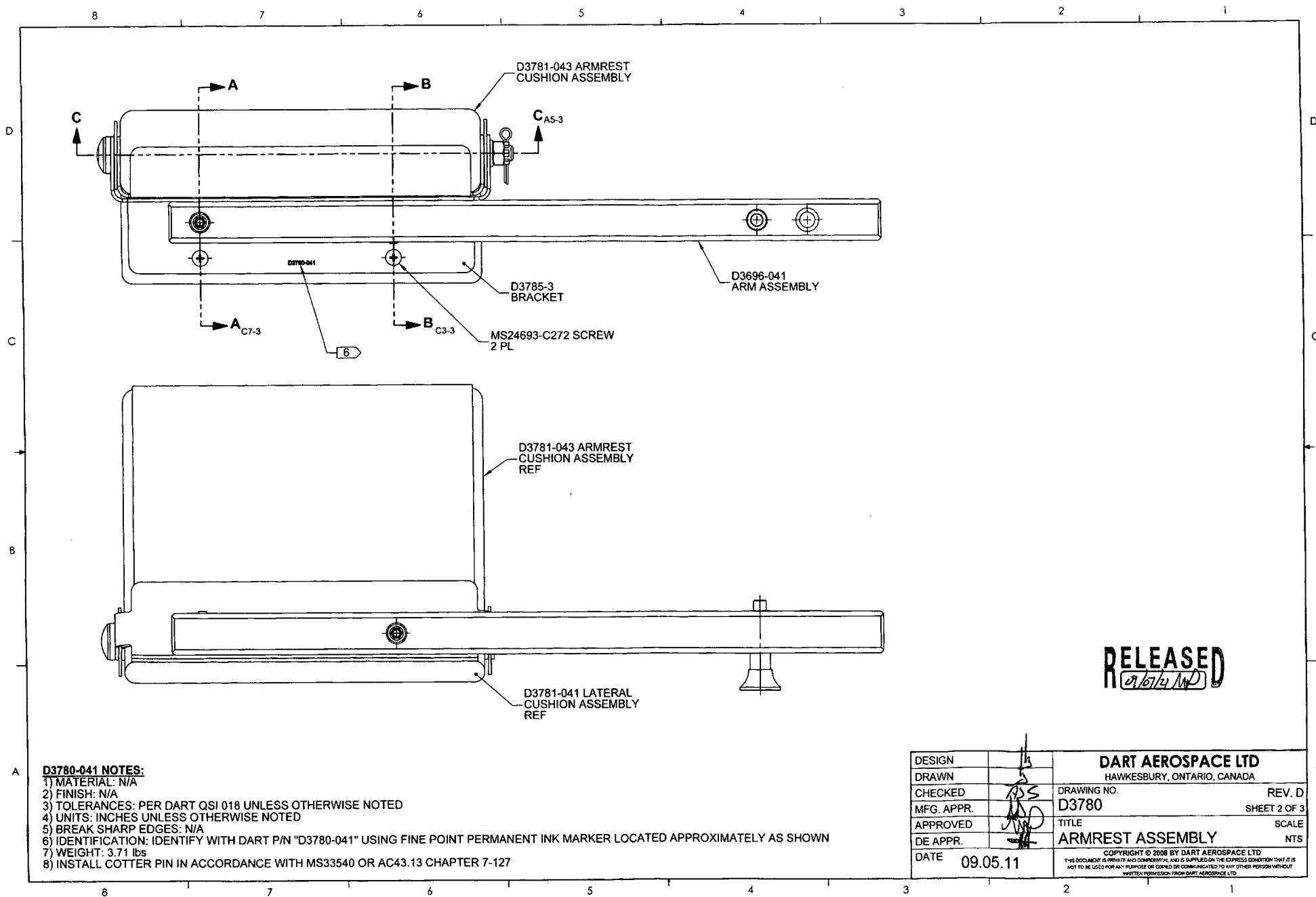
ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3696-041	ARM ASSEMBLY
4	1	D3781-041	LATERAL CUSHION ASSEMBLY
5	1	D3781-043	ARMREST CUSHION BASE ASSY
6	1	D3785-3	BRACKET
7	1	D3977-1	BOLT (CARRIAGE), UNC
8	1	D3978-1	NUT (CASTELLATED), UNC
9	1	D3979-1	WASHER (SQUARE HOLE)
12	2	AN960JD10L	WASHER
13	2	AN970-6	WASHER
14	2	MS21042L3	NUT
15	1	MS24665-302	COTTER PIN
16	2	MS24693-C272	SCREW
17	2	MS24693-C277	SCREW
18	1	NAS1149D0663J	WASHER

RELEASED
07/07/21

20151117 SH 139237

D	REDESIGNED BASED FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.11
C	UPDATED BOM TO CURRENT STANDARDS, REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE

DESIGN	1/5	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	1/5		
CHECKED	1/5	DRAWING NO. D3780	REV. D
MFG. APPR.	1/5	TITLE ARMREST ASSEMBLY	SHEET 1 OF 3
DE APPR.	1/5	SCALE	NTS
DATE	09.05.11	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3780	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	09.05.11	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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D3781-041 LATERAL
CUSHION ASSEMBLY
REF

D3781-043 ARMREST
CUSHION ASSEMBLY
REF

MS21042L3
NUT
AN960JD10L
WASHER
MS24693-C272
SCREW

SECTION A-A C7-2

D3781-043 ARMREST
CUSHION ASSEMBLY
REF

MS24693-C277
SCREW

D3781-041 LATERAL
CUSHION ASSEMBLY
REF

D3785-3
BRACKET
REF
AN960JD10L
WASHER
MS21042L3
NUT
MS24693-C272
SCREW

SECTION B-B C6-2

AN970-6 WASHER
2 PL

NAS1149D0663J
WASHER

D3978-1 NUT (CASTELLATED), UNC
MS24665-302 COTTER PIN (8)

D3785-3 BRACKET
REF

D3977-1 BOLT (CARRIAGE), UNC

D3781-043 ARMREST
CUSHION ASSEMBLY
REF

D3979-1 WASHER (SQUARE HOLE)

SECTION C-C D5-2
SCALE: 2X

RELEASED
07/04/11

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3780	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	09.05.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	